

Date: Tuesday, 10/17/2006 11:19:53 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD		
Job Number	: 29038					
Estimate Number	: 10313					
P.O. Number	: N/A		Part Number	: D26483		
This Issue	: 10/17/2006 S.O. No. : N/A		Drawing Number	: D2648 REV D		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: D		
Previous Run	: 28249		Material	: N/A		
Written By			Due Date	: 10/30/2006 Qty: 50 Um: Each		
Checked & Approved By						
Comment	: Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF Est Rev:F Now on Waterjet 06-08-14 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET
		 Comment: Qty.: 0.0788 sf(s)/Unit Total : 3.9375 sf(s) 1010/1025/A21/6aA SHEET (M1010S16GA) Batch: m9131 ml 06 12 05
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D2648 *****CUT WITH FILE D2648-1***** Dwg Rev: D Prog Rev: D ml 06 12 05
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		 Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/01/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/17/2006 11:19:54 AM
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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D2648-3

SB α/12/19. (50)

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 560 Hardcoat m102885

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

MF. 07/01/03 (50)

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

9.0 QC5

INSPECT WORK TO CURRENT STEP



AA 07/01/03 (50)

Comment: INSPECT WORK TO CURRENT STEP

AA 07/01/03 (50)

10.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

SP. / am 07/01/04 (50)

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 07/01/04 (50)

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: FP17

FC 07/01/04 (50)

13.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

A 07.01.05

11070105

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29038
Description: Wearpad	Part Number:	D2648-3
Inspection Dwg: D2648	Rev: D	Page 1 of 1

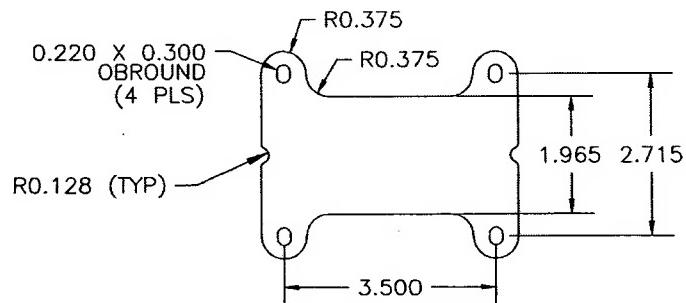
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

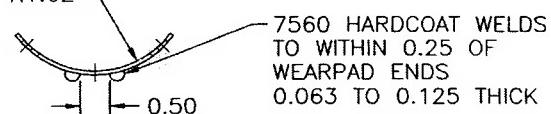
Measured by:	<i>MM</i>	Audited by:	<i>AS</i>	Prototype Approval:	N/A
Date:	06/12/05	Date:	06/12/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.16	New Issue	KJ/JLM	<i>[Signature]</i>

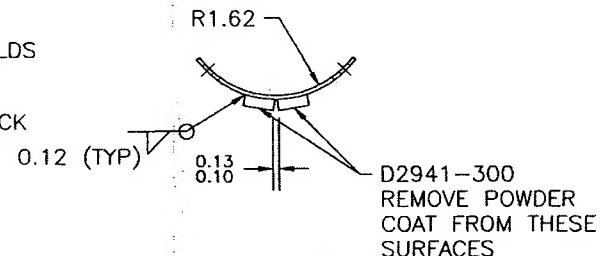
D2648-1 FLAT PATTERN



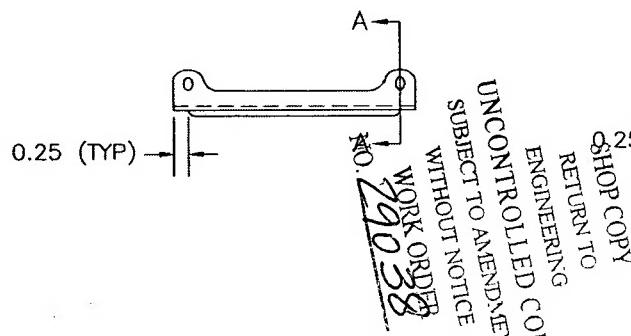
SECTION A-A



SECTION B-B

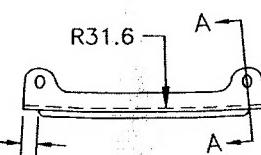


D2648-3 LONGITUDINAL BEND
(MADE FROM D2648-1)

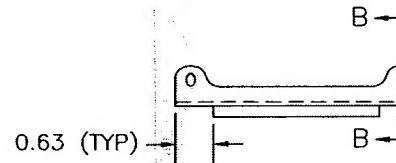


BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

D2648-5 LONGITUDINAL BEND
(MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND
(MADE FROM D2648-1)



RELEASED
94.12.20 DS



D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBRound, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY RF	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED H	DRAWING NO. D2648
DATE	99.11.17	TITLE WEARPAD
		REV. D SHEET 1 OF 1 SCALE 1:2